




Woodworking insert Ø23 Z4

A09-950

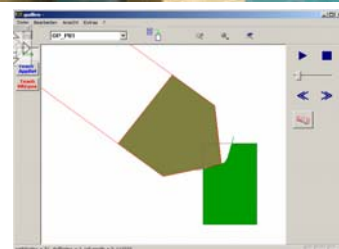
Thanks to the TTC system this insert is ground automatically in one clamping. The use of a biconical grinding wheel for the VSW profil grinding in QUINTO allows to cover all the grinding tasks for concave radius and very short production time. The two faces are dressed easily by oscillating on an corund wheel the ensure high precision for very long time.



1. Cycletime for Production

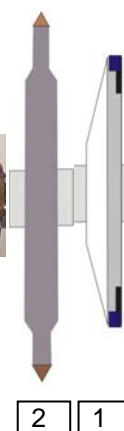
Workpiece: Ø 23 mm, Z 4, L 6 mm, R1.5 Material CARBIDE					
Operations	Palpage	Coupe	Dos droit	Rayon	Chargement
Feed [mm/Min]	2000	400	400	300	9000
Power [kW]		4	1	1	1
Cutting feed [m/s]		22	22	22	
Used wheels					
Grinding time [s]	10	32	32	68	11
Total cycle time	2 Min 33				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	12C9 Ø300 D64C125
2	14V1 Ø300 D64V110°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 160i

Accessories: STL6050, Dressing unit

Responsible engineer: OP 10.7.09

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5